

LEXAN™ BY2710X resin

Polycarbonate

SABIC Innovative Plastics Asia Pacific

Message:

BY2710X is a modified Polycarbonate (PC) resin. It is a non-filled, injection moldable grade with UL-94 V0 rating and is available in various opaque color options.

General Information			
UL YellowCard	E207780-101074407		
Appearance	Colors Available Opaque		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.19	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.60 to 0.80	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	2220	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	60.0	MPa	
Break	61.0	MPa	
Tensile Elongation ³			ASTM D638
Yield	6.0	%	
Break	100	%	
Flexural Modulus ⁴ (50.0 mm Span)	2070	MPa	ASTM D790
Flexural Strength ⁵ (Yield, 50.0 mm Span)	90.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
0°C	740	J/m	
23°C	800	J/m	
Instrumented Dart Impact (23°C, Total Energy)	72.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	139	°C	ASTM D1525 ⁶
Ball Pressure Test (125°C)	Pass		IEC 60695-10-2
RTI Elec	130	°C	UL 746
RTI Imp	115	°C	UL 746
RTI Str	125	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		UL 94

Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	3.0 to 4.0	hr
Drying Time, Maximum	48	hr
Suggested Max Moisture	0.020	%
Suggested Shot Size	40 to 60	%
Rear Temperature	217 to 293	°C
Middle Temperature	282 to 304	°C
Front Temperature	293 to 316	°C
Nozzle Temperature	288 to 310	°C
Processing (Melt) Temp	293 to 316	°C
Mold Temperature	71.0 to 93.0	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.025 to 0.076	mm

NOTE

1. 50 mm/min
2. Type I, 50 mm/min
3. Type I, 50 mm/min
4. 1.3 mm/min
5. 1.3 mm/min
6. Rate B (120°C/h), Loading 2 (50 N)

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